

Date: Tuesday, 10/30/2007 2:49:42 PM
User: Kim Johnston

Process Sheet

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	350/355 DUALCARGO MIRROR
Job Number	:	35448			
Estimate Number	:	12028			
P.O. Number	:	N/A	Part Number	:	D350561043
This Issue	:	10/30/2007 S.O. No. : N/A	Drawing Number	:	IIN D350-561 REV C
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : SMALL /MED FAB	Drawing Revision	:	C
Previous Run	:	33951	Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	11/25/2007 Qty: 5 Um: Each
Checked & Approved By	:	<u>[Signature] 07 10 31</u>			
Comment	:	Est Rev: 05.09.15 Step 11 pick list revised per D350-561 Rev. C KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-561-043 CHG005

6 A11 15 07.10.31

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2011101	Mirror 6"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Mirror

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2 D2011-101 Mirror

Batch
033916

Sub.

D2012101 Arm (23.75)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Arm

Pick: Packing Kit

Qty	Part Number	Description	Batch
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1 D2012-101

Arm

Batch 1532549

7/11/02 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Job Number: 35448

Part Number: D350561043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012103

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Arm

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2012-103

Arm

35462

50

7-11-19

6.0

D2012105

Arm (31.06)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Arm

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2012-105 Arm

134303

50

7.0

D2012107

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Clevis

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2012-107

Clevis

1333885

50

8.0

D2012109

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2012-109

Bracket

1324558

50

9.0

D2012111

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2012-111

Bracket

1330300

50

7/11/05 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0
HTT

D2012113

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number

Description Batch

6 D2012-113

Clamp

M22552

SP

11.0
HTT

D2012115

Bracket,Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2012-115

Bracket

M25581 SP

12.0
HTT

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2022-101

Spacer

M30543

SP

7/11/5 SP

13.0
HTT

D2856100325

Abrasion Strip



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Abrasion Strip

Pick: Packing Kit

Qty Part Number

Description

Batch

6 D2856-100-(3.25) Abrasion Strip

B34642

SP

14.0
HTT

AN34A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN3-4A Bolt

M03287

mf. 7/11/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350561043

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

AN35A

Bolt

HH



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN3-5A

Bolt

m100188

mf

16.0

AN36A

Bolt

HH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN3-6A

Bolt

m100184

mf

17.0

AN45A

Bolt

HH



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description Batch

3 AN4-5A Bolt

m100857

mf.

18.0

AN410A

Bolt

HH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-10A

Bolt

m103962-x 8mx, m104603 x 2mx.

mf 07-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 35448

Part Number: D350561043

Job Number:



Seq. #:

Machine Or Operation:

Description :

HHH

19.0

AN960JD10

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description Batch

20 AN960JD10

Washer m104625

mf

HHH

20.0

AN960JD416

Washer



Comment: Qty.: 11.0000 Each(s)/Unit Total : 55.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description Batch

11 AN960JD416

Washer m105426

mf.

HHH

21.0

MS21042L3

Nut



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description Batch

7 MS21042L3

Nut (or -3) m104625

mf

HHH

22.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description Batch

5 MS21042L4

Nut (or -4) m105054

mf

07-11-02

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

mf 07-11-19

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-561-043

Location:

PPP Rev:

G

7-11-19 (5x) 54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 350/355 DUALCARGO MIRROR

Job Number: 35448

Part Number: D350561043

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

20/11/19

Job Completion



u 07-11-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-561-041	2.5 lb	+39.0 in	+97.5 in-lb	9.0 in	22.5 in-lb
Single Mirror Installation	1.1 kg	+0.99 m	+1.09 m-kg	0.23 m	0.25 m-kg
D350-561-043	3.2 lb	+40.0 in	+128.0 in-lb	8.8 in	28.2 in-lb
Dual Mirror Installation	1.5 kg	+1.02 m	+1.53 m-kg	0.22 m	0.33 m-kg

5. PARTS LIST

Qty -041	Qty -043	Qty -045	Part Number	Description
X	1	1	D350-561-041	SINGLE MIRROR INSTALLATION
	X		D350-561-043	DUAL MIRROR INSTALLATION
	1	X	D350-561-045	MIRROR KIT
1		1	D2011-101	Mirror
1			D2012-101	Arm
1			D2012-103	Arm
1			D2012-105	Arm
2			D2012-107	Clevis
1			D2012-109	Bracket
1			D2012-111	Bracket
4		2	D2012-113	Clamp
1			D2012-115	Bracket
4			D2022-101	Spacer
4		2	D2856-100-325	Abrasion Strip
1*		1*	D3014-1	Locknut
2		1	AN3-4A	Bolt
2		1	AN3-5A	Bolt
1			AN3-6A	Bolt
3			AN4-5A	Bolt
2			AN4-10A	Bolt
14		6	AN960JD10	Washer
9		2	AN960JD416	Washer
1*		1*	AN960JD416L	Washer
5		2	MS21042L3	Nut (or MS21042-3)
5			MS21042L4	Nut (or MS21042-4)

*INCLUDED AS PART OF D2011-101 MIRROR

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 35448

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Revision: C
 Date: 05.06.13